

Date: Monday, 09/02/2009 8:58:33 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE HALF
Job Number	: 45605		
Estimate Number	: 13142		
P.O. Number	:	Part Number	: D37481
This Issue	: 09/02/2009 S.O. No. :	Drawing Number	: D3748 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 38225	Material	:
Written By	:	Due Date	: 09/02/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>MF 09-02-09</u>		
Comment	: Est Rev:A 08-01-30 new issue DD verified by:EC Est Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S11GA	304/316 0.125 Sheet
-----	-----------	---------------------



Comment: Qty.: 0.0358 sf(s)/Unit Total : 0.1432 sf(s)
 304/316 stainless steel sheet .125" thick
 (M304S11GA)
 Batch: 109358 B 9-2-9

(10)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3748
 Dwg Rev: A
 Prog Rev: A

B 9-2-9

2- Deburr if necessary

M-109/02/09

(10x)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-2-9

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 09/02/09

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr if necessary

/ 1/1A 5

Date: Monday, 09/02/2009 8:58:33 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE HALF

Job Number: 45605

Part Number: D37481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/75

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3748

SB 09/02/10

(1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/10 (x10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket CELL

0902-10

(x10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



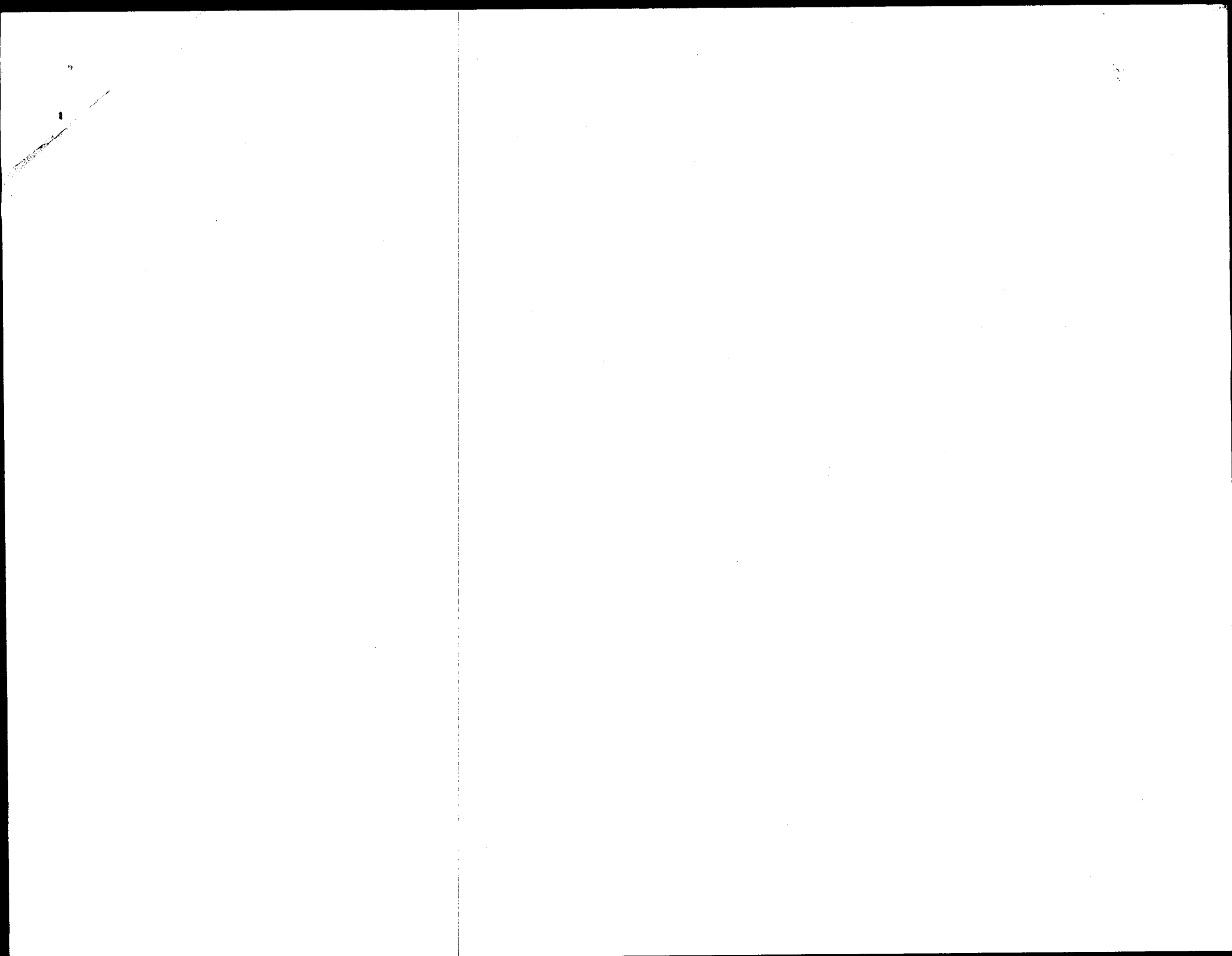
Comment: FINAL INSPECTION/W/O RELEASE

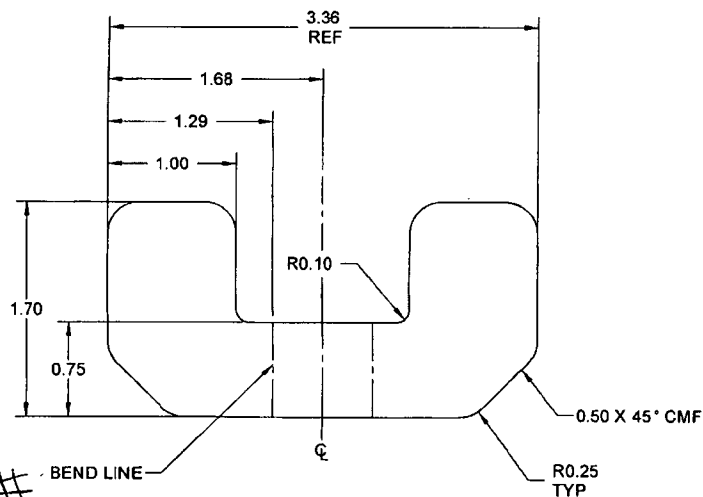
09/02/10

Job Completion

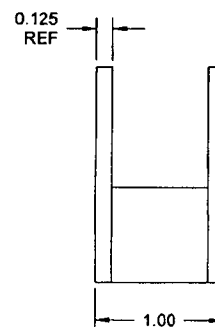
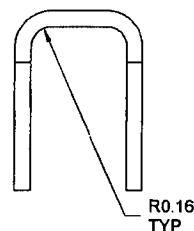


-MF
09-02-10

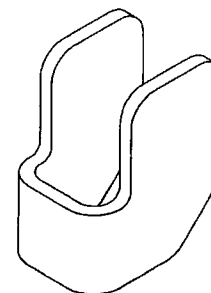




D3748-1F FLAT PATTERN



D3748-1 HINGE HALF



- NOTES:
- MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
 - FINISH: NONE
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: N/A
 - WEIGHT: 0.15 lbs

A INITIAL RELEASE		AJS	08.02.05
REV.	DESCRIPTION		BY DATE
DESIGN	AJS		
DRAWN	ASS		
CHECKED	LE		
MFG. APPR.	N/A		
APPROVED	N/A		
DE APPR.	N/A		
DATE	08.02.05		
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3748 REV. A SHEET 1 OF 1 TITLE HINGE HALF SCALE 1:1 <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	